

Date: Tuesday, 10/30/2007 2:51:05 PM
 User: Kim Johnston

Process Sheet

45

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 35458C	
Estimate Number : 10302	
P.O. Number : <u>N/A</u>	Part Number : D32391
This Issue : 10/30/2007 S.O. No. : <u>N</u>	Drawing Number : D3239 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>11</u> Type : MACHINED PARTS	Drawing Revision : <u>A</u>
Previous Run : 35196C	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 11/6/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>20</u> Um: <u>8</u> Each
Comment : Est Rev. A New Issue 05-11-06 JLM Est: b 06.11.15 waterjet EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.1890 sf(s)/Unit Total : 1.5120 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.050" thick
 (M6061T6S0.050)
 Identify for D3239-1
 Batch: 17347 HB 07-11-S

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3239
 Dwg Rev: A
 Prog Rev: A

HB 07-11-S20

2-Deburr if necessary HB 07-11-S

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 07-11-S

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6/2/11/0520

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

N/ADone at SEP 226/2/11/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 21/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D32391

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS

07-11-07

(20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP

7-11-06

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

78

7/11/7

SP

(20x)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/11/09

Job Completion



U 07-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

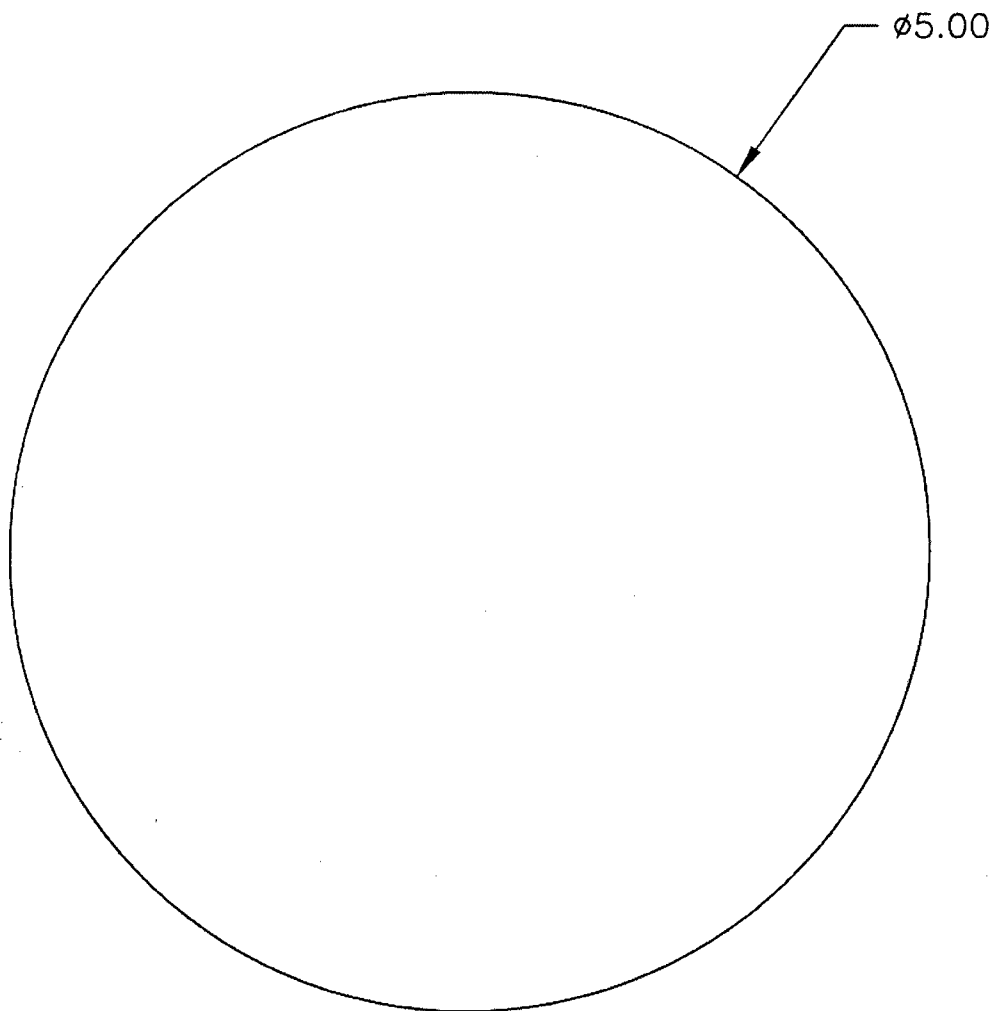
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3239	REV. A SHEET 1 OF 1
DATE 03.12.19		TITLE COVER	SCALE 1:1
A	03.12.19	NEW ISSUE	

RELEASED
04.02.03



D3239-1 COVER

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35458C

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